

Work Order ID 81743

81743

Page 1

March-16-12 3:18:55 PM

Item ID: D3688-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: STUD
 Start Date: 16/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 23/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3688	Rev C								

100
100 BAND SAW 0.00
 Bandsaw Memo 0.00 SL 12-08-09 12
 Jeaspa Bandsaw ***DO NOT USE CHOP SAW*** Cut blank 11.673" long

110
110 DOOSAN LATHE 0.00
 Doosan Memo 0.00 SL 12/29 12 4
 Doosan Lathe 1-Turn as per Folio FA718 Rev. AK & Dwg D3688 Rev. C 2-Deburr 12.8.11
 per dwg D3688
 3-Check .625" bore with DT9530 GO/NO GO Gauge

120
120 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00 2/12.8.11 12 4
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81743

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Page 2

March-16-12 3:18:55 PM

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 Start Date: 16/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 23/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC8- Inspect parts - second check Memo 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT	0.00 0.00				12	0		
180 *180* Purchasing Purchasing	PURCHASING Memo Issue P/O: 17896 LPI Per ASTM 1417 LEVEL 2Certificate of conformity is required	0.00 0.00				12x			SP 12-8-11
190 *190* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Ensure certificate of conformity is attached	0.00 0.00							Pto → C12/4/12 (12)

DAS
13
9-89

12/8/14

12-09-12

W/O: 81743		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3688-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: AWR Date: 12/10/17
 Resolution: _____ Disposition: Rework QA: N/C Closed: CK Date: 12/10/17

NCR: 12-1922		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/17	#120	Qty +1 Stud Found with Indication in Shank From NDT R-C From machining Process.		Due to it's Function on Engine mounts Part is Scrap Do not Repair.				DAS 16 9-89 17/06/17
			DAS 12 9-89 12/10/10	Machine Area to meet Acceptable Dim → FINAL DIM = 0.652 = OK Re NDT to Findout if it's acceptable. FINAL DIM = 0.652 = OK	SD 12-09-27		DAS 12 9-89 12/10/10	DAS 16 9-89 12/06/17
			DAS 12 9-89 12/10/10	LPI per ASTM 1417 LEVEL 2 CERT. OF CONFORMITY REQ'D PIU: _____			DAS 12 9-89 12/10/10	

NOTE: Date & initial all entries

Work Order ID 81743

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Page 3

March-16-12 3:18:55 PM

Item ID: D3688-1 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 16/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 23/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200 QC5- Inspect part completeness to step on W/O 0.00

200

QC

Quality Control

Memo

0.00

210

Identify as per dwg & Stock Location **GA Gk** 0.00

210

Packaging

Packaging

Memo

0.00

220

QC21- Final Inspection - Work Order Release 0.00

220

QC

Quality Control

Memo

0.00

DAS 16 *data*

12/10/05

12/08/15 **SP**

12/10/11 **SP**

12-10-05 **SP**

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-16-12 3:18:59 PM

Page 1

Work Order ID: 81743

81743

Parent Item: D3688-1

D3688-1

Parent Item Name: STUD

Start Date: 16/03/2012

Required Date: 23/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
 IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
 IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC
 IPP REV:D 10.07.06 revo step 130-160 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No			100	f	45.2000	1.087	13.73053			

M174PH-H900R1 000

17-4SS H900 ROUND BAR 1.00

**

22 12-08-10

Location

Loc Qty

Loc Code

MAT030

45.2

117445

21.2

120767

24

121 918 x 1

1.15

121 280 x 11

12-65

1.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 81743
Description: Stud		Part Number: D3688-1
Inspection Dwg: D3688 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.685	/		Q. 02	
0.625	+0.004/-0.000	.628	/			
1.25	+0.000/-0.03	1.220	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	.02	/			
0.11 Ref	+/-0.030	.11	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.190	/			
1.31	+/-0.030	1.310	/			
1.65	+/-0.030	1.650	/			
0.870	+0.000/-0.010	.868	/			
Ø0.659	+0.000/-0.015	.656	/			
11.573	+/-0.015	11.575	/			
2.90	+/-0.030	2.90	/			
3/4-16UNF-2A	N/A	2A	/			
0.075 x 45°	+/-0.010 x 0.5°	.085	/			
0.370	+0.000/-0.010	.368	/			
Ø0.189	+0.005/-0.001	.190	/			
R0.25	+/-0.030	R.25	/			
R0.50	+/-0.030	R.50	/			

Measured by: DP	Audited by: DA 13	Prototype Approval:	N/A
Date: 12-8-11	Date: 12/8/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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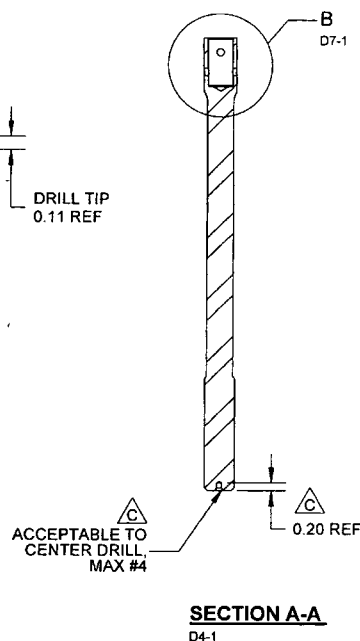


WITHOUT NOTICE
WORK ORDER.

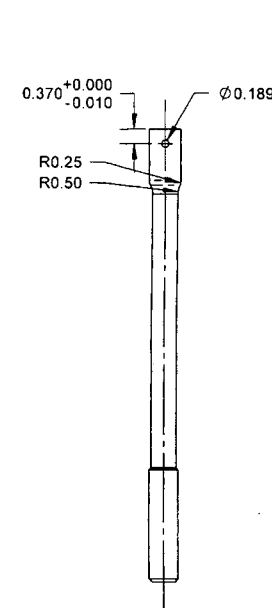
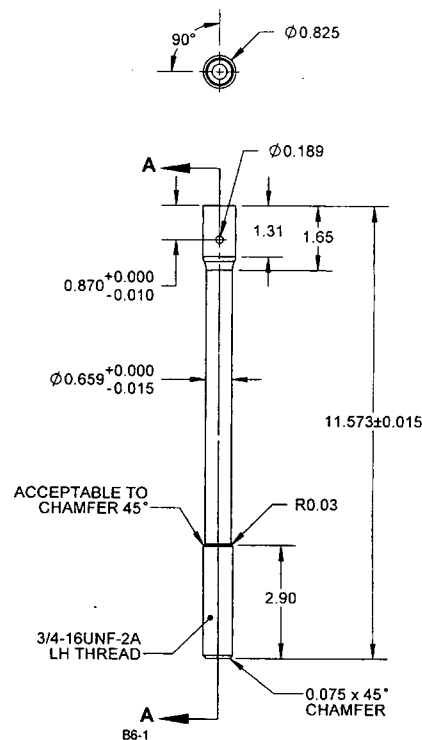
WORK ORDER
NO. 01743 MLJ

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.24 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)



D3688-1 STUD



RELEASE
2008-09-22

C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B6-3, B6-4) UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REDUCE LENGTH ON D3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTO TYPE INS. L.; 0.0.65 WAS 0.0.65 (ZN D8-1, D8-2, D8-3); 0.508 WAS 0.478 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	REV.	
CHECKED	90	DRAWING NO.	SHEET 1 OF
MFG. APPR.	21	D3688	SHEET 1 CAL
APPROVED	10	TITLE	NT
DE APPR.	14	STUD	
DATE	09.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

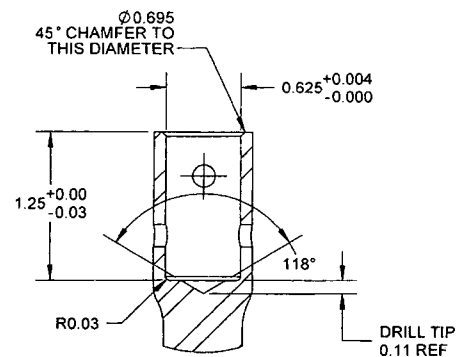
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

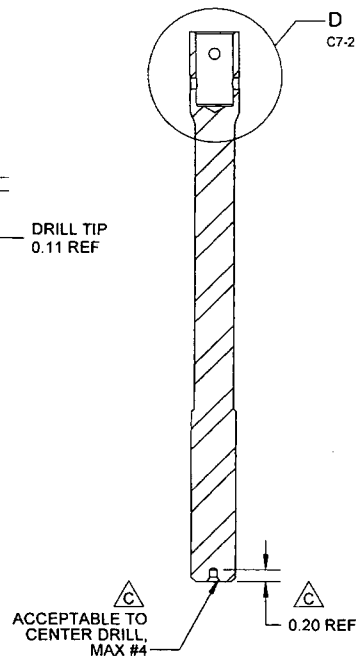
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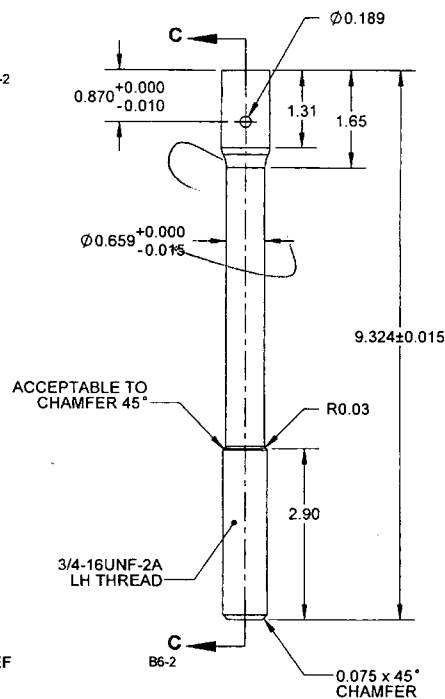
NOTE: Date & initial all entries



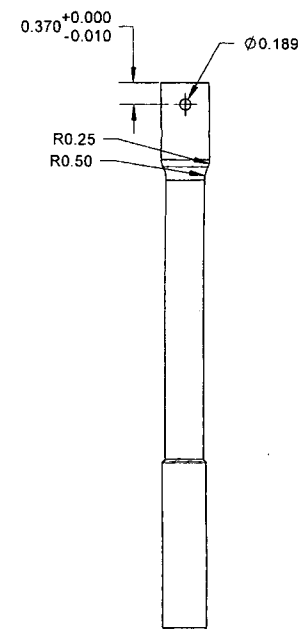
DETAIL D
SCALE 2X
D6-2



SECTION C-C
D4-2



D3688-3 STUD



RELEASED
2009-09-22

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3688	SHEET 2 OF 4
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	STUD	NTS
DATE	09.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

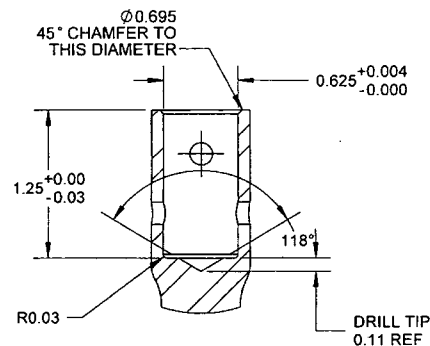
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

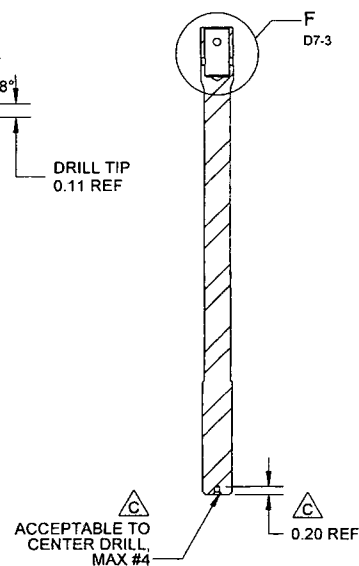
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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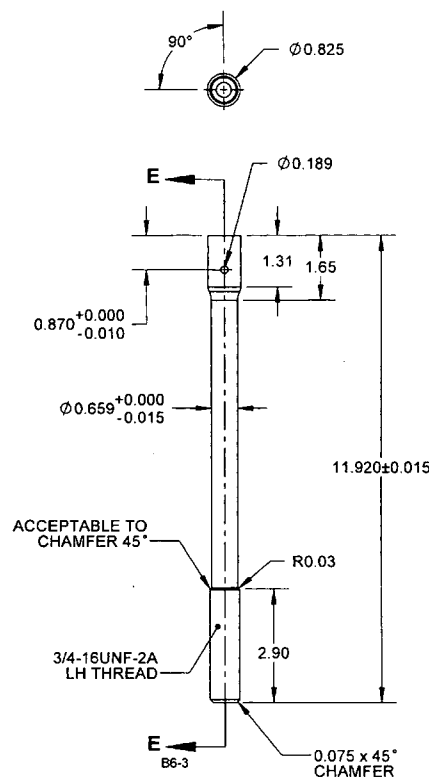
NOTE: Date & initial all entries



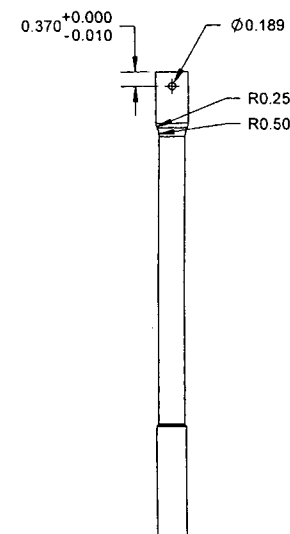
DETAIL F
SCALE 3X
D6-3



SECTION E-E
D4-3



D3688-5 STUD



RELEASED
2009-09-22

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3688	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STUD	NTS
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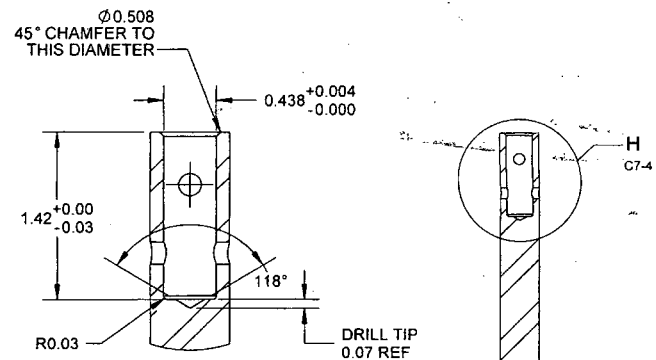
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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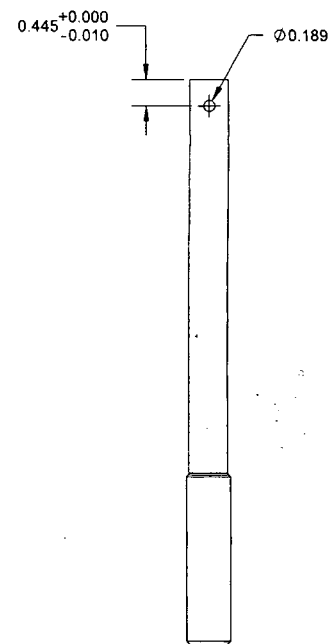
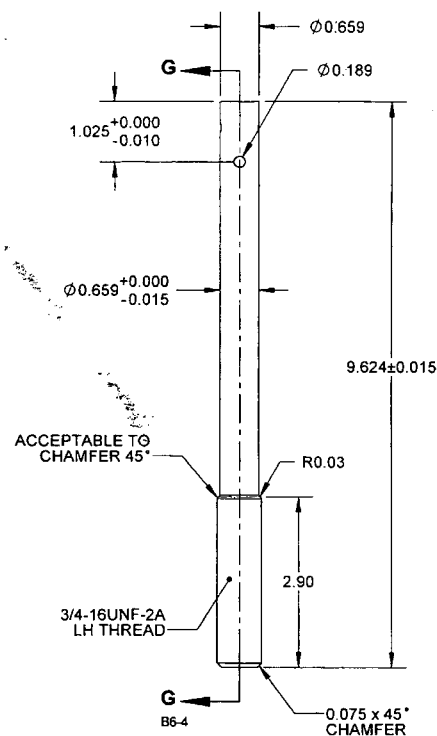
DETAIL H
SCALE 2X
D6-4

ACCEPTABLE TO
CENTER DRILL,
MAX #4

0.20 REF

SECTION G-G
D4-4

D3688-7 STUD



RELEASED
2009-09-22

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3688	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	STUD	NTS
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12678

CLIENT DART Aerospace DATE SEPT-12-12 PAGE 1 OF 1
ATTENTION MAT/LINDA ACUREN JOB NO. 100-12-C0342 TIME AM ☒ PM ☐
ADDRESS 1270 ABELDEEN POWO No. -
HAWKESBURY, ON. WORK LOCATION SAME
ACCEPTANCE STD. ASTM 1417/AS-038 REV./DATE 2005
PROJECT F.P.I. MACHINED PARTS AND CROSS TUBES.
M(S) EXAMINED 1 STUD, 5 CROSS TUBES

JOB DESCRIPTION PROCEDURE No. LT 002 REV./DATE 2008 TECHNIQUE No. LT 002 REV./DATE 2008
PART NO. SEE RESULTS MATERIAL STEEL/ALUMINUM THICKNESS VARIOUS
SCOPE A WET FLUORESCENT LIQUID PENETRANT INSPECTION WAS
CARRIED OUT ON THE 100% OF THE EXTERNAL SURFACE.

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER 120 MINIMUM DRY TIME >10 MIN. OTHER LABINO - 11-29-12.
DEVELOPER MAGNAFLUX MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N - CAL DUE DATE -
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F
RESULTS- ☐ METRIC ☐ IMPERIAL

W.O. # CROSS TUBE

1 - 88857	"	"	✓	INDICATIONS REPORTED WITH REGRIND
1 - 88043	"	"	✓	
1 - 89708	"	"	✓	
1 - 89711	"	"	✓	
1 - 88856	"	"	✓	
1 - 81743	STUD	✓	✓	REGRIND Scribble

Scope of Services
Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as a warranty. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of inspection or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
The services provided by Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Matthew Marshall PRINT Matthew Marshall SIGNATURE DTR # E120227
TECHNICIAN (SIGNATURE): Mike Harris
NAME (PRINT): Mike Harris 1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL # SNT LEVEL - CGSB LEVEL - SNT LEVEL -
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